

49

Date: Wednesday, 11/21/2007 12:50:58 PM
 User: Kim Johnston

Process Sheet

| | |
|--|--------------------------------------|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : UTILITY BASKET LH/RH |
| Job Number : 35936 | |
| Estimate Number : 10236 | |
| P.O. Number : | Part Number : D350607047 |
| This Issue : 11/21/2007 S.O. No. : | Drawing Number : D350-607 REV F |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : 1 / Type : LARGE FAB ASSY | Drawing Revision : F |
| Previous Run : 31265 | Material : |
| Written By : | Due Date : 12/6/2007 Qty: 1 Um: Each |
| Checked & Approved By : <u>07.11.21</u> | |
| Comment : Est Rev:B Re-Format 05-11-03 JLM | |
| Est Rev:C As per DSI9318 06-09-05 JLM | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
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| 1.0 | DC | DOCUMENT CONTROL |
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Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPPD350-607-047 CHG001

CHG002

08/01/24

07.11.12

| | | |
|-----|--------|-------------------------|
| 2.0 | 35936A | 350 BASKET BASE (SHORT) |
|-----|--------|-------------------------|



Comment: Sub-Component 350 BASKET BASE (SHORT)

D3265-041 B 35936 A

ml 08/01/23

| | | |
|-----|--------|---------------------|
| 3.0 | 35936B | BASKET LID ASSEMBLY |
|-----|--------|---------------------|



Comment: Sub-Component BASKET LID ASSEMBLY

D3267-043 B 35936 B

ml 08/01/23

| | | |
|-----|--------|---------------------|
| 4.0 | 35936C | BASKET LID ASSEMBLY |
|-----|--------|---------------------|



Comment: Sub-Component BASKET LID ASSEMBLY

D3267-041 B 35936 C

ml 08/01/23

| | | |
|-----|-------------|-----------------------|
| 5.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1

Pick: Assembly Kit

| | | |
|-----|----------|--------|
| 6.0 | D2022101 | Spacer |
|-----|----------|--------|



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Spacer

Batch: 1033985

8/1/22 SP (14)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Date: Wednesday, 11/21/2007 12:50:58 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: UTILITY BASKET LH/RH

Job Number: 35936

Part Number: D350607047

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

D2258200

Weight Placard 200lb



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2258-200

Label

1235944

SP

8.0

D2332041

Lid Prop Assembly 6.69"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2332-041

Prop Ass'y

1235718

SP

9.0

D2530

Handle Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2530

Handle Weldment

1235351

SP

10.0

D2535

Spring



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2535

Spring

1234890

SP

11.0

D2537

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2537

Bushing

1234788

SP

12.0

D27283

Dart Logo label large



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2728-3

Label

1222553

8/1/22

SP (12)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Date: Wednesday, 11/21/2007 12:50:58 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: UTILITY BASKET LH/RH

Job Number: 35936

Part Number: D350607047

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

D2931

Bumper



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 D2931

Bumper

1221139

SP

14.0

AN316A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN3-16A

Bolt

1104603

SP

15.0

AN413A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN4-13A

Bolt

1106513

SP

16.0

AN422A

Bolt



Comment: Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

7 AN4-22A

Bolt

1104625 (2X)

1104937

(3X)

SP

17.0

AN517A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

4 AN5-17A

Bolt

1104885

SP

18.0

AN960JD8

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN960JD8

Washer

1106112

8/1/22 SP (A)

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Date: Wednesday, 11/21/2007 12:50:59 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: UTILITY BASKET LH/RH

Job Number: 35936

Part Number: D350607047

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

AN960JD416

Washer



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

14 AN960JD416 Washer M106277

SP

20.0

AN960JD416L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 AN960JD416L Washer M106303

SP

21.0

AN960JD516

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN960JD516 Washer M106167

SP

22.0

AN9704

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN970-4 Washer M105442

SP

23.0

MS20600AD4W3

Cherry Rivets



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 MS20600AD4W3 Rivet M18071

SP

24.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 MS21042L3 Nut (or -3) M105558

8/1/02 SP (x)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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Date: Wednesday, 11/21/2007 12:50:59 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: UTILITY BASKET LH/RH

Job Number: 35936

Part Number: D350607047

Job Number:



Seq. #:

Machine Or Operation:

Description :

25.0

MS21042L4

Nut



Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)
nut

Batch: M105054

SP

26.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick: Assembly Kit

Qty Part Number

Description Batch

4 MS21042L5

Nut (or -5)

M105940

8/1/22 SP (1A)

27.0

NAS1515H4

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Washer

Batch: M101369

8/1/22 SP (1A)

28.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1.



x1

Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per Dwg D350-607

m108/01/23

29.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

208-01-23 (1)

30.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Pick: Packing Kit

31.0

D22301

Mounting Lug



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick: Packing Kit

Qty Part Number

Description Batch

4 D2230-1

Lug

A33250

8/1/23 SP (1A)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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QA: N/C Closed: _____ Date: _____

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Drawing Name: UTILITY BASKET LH/RH

Job Number: 35936

Part Number: D350607047

Job Number:



Seq. #:

Machine Or Operation:

Description :

32.0

D22303

Mounting Lug



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

4 D2230-3

Clamp

1535800

SP

33.0

D23241

Strut Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 *D2324-1

Strut Ass'y

1534291

SP

34.0

D2856400

Abrasion Strip



Comment: Qty.: 0.6000 f(s)/Unit Total : 0.6000 f(s)

Pick: Packing Kit

Qty Part Number

Description Batch

4 D2856-400-720 Abrasion Strip

1535900

SP

35.0

AN412A

Bolt



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

5 AN4-12A

Bolt

M105143

SP

36.0

AN413A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

8 AN4-13A

Bolt

M106513

SP

37.0

AN960JD416

Washer



Comment: Qty.: 26.0000 Each(s)/Unit Total : 26.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

26 AN960JD416

Washer

M106277

8/1/23 SP

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | | |
|----------|----------|---|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| 08.01.23 | 40 30 | ADD TO KIT: Qty (8) D2732-030 Rubber Cushion B/N Qty (8) AN4-15A Bolt B/N PER ECN 1068 & DSI 9380 Rev.B | | | | CP 08.01.23 DSI 042 | CP 08.01.23 | |
| 08.01.23 | | ENSURE PAPERWORK HAS COPY OF DSI 9380 Rev.B ENSURE ALL LABELS ARE SAY CHG 002 | | | | CP 08.01.23 per DSI 042 | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Date: Wednesday, 11/21/2007 12:50:59 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: UTILITY BASKET LH/RH

Job Number: 35936

Part Number: D350607047

Job Number:



Seq. #:

Machine Or Operation:

Description :

38.0

MS21042L4

Nut



Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

13 MS21042L4

Nut (or -4)

M105057

8/1/23

SC

(12)

39.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

5

08/01/04

(XL)

40.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-607-047

Location: *B*

8/01/07

(1)

41.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08.01.25

JA

Job Completion



1 x DSI9380.04 B 34003

SC

8/1/23



(12)

per ECN1008

min 2008/1/24

4

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|----------|------|--|----|------|-----|---|---|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| 08.01.23 | 30 | ADD DST REMOVE DZ856-460 ABRASION STRIPS FROM KIT | | | |  08.01.23 pu 051642 |  08-01-23 |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

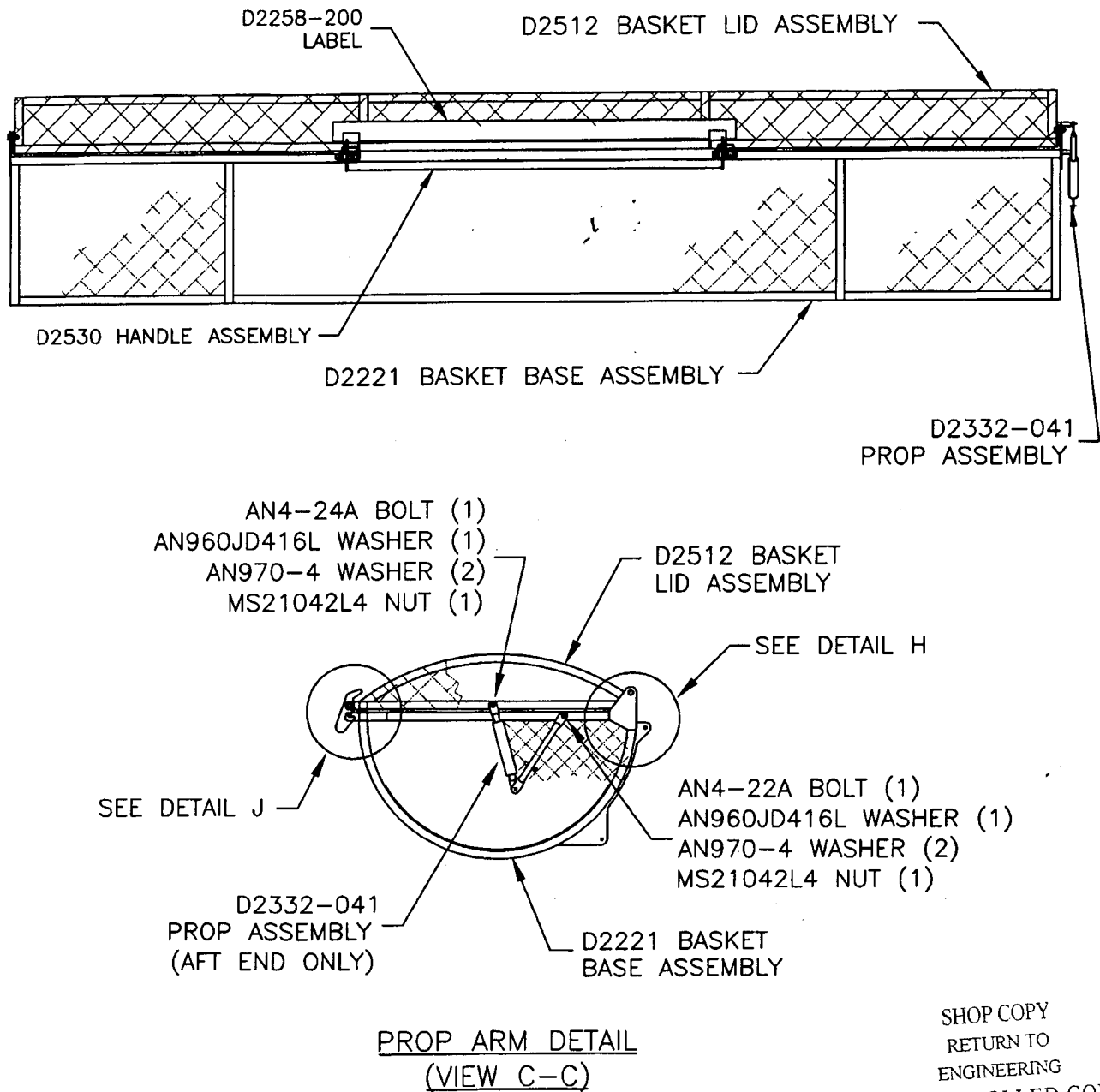


Figure 4 – Basket Replacement Parts
(D350-607-041 Heli-Utility-Basket™)

SHOP COPY
RETURN TO
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WITHOUT NOTICE
WORK ORDER
NO. 35936

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Revision: **F**
Date: 03.01.17

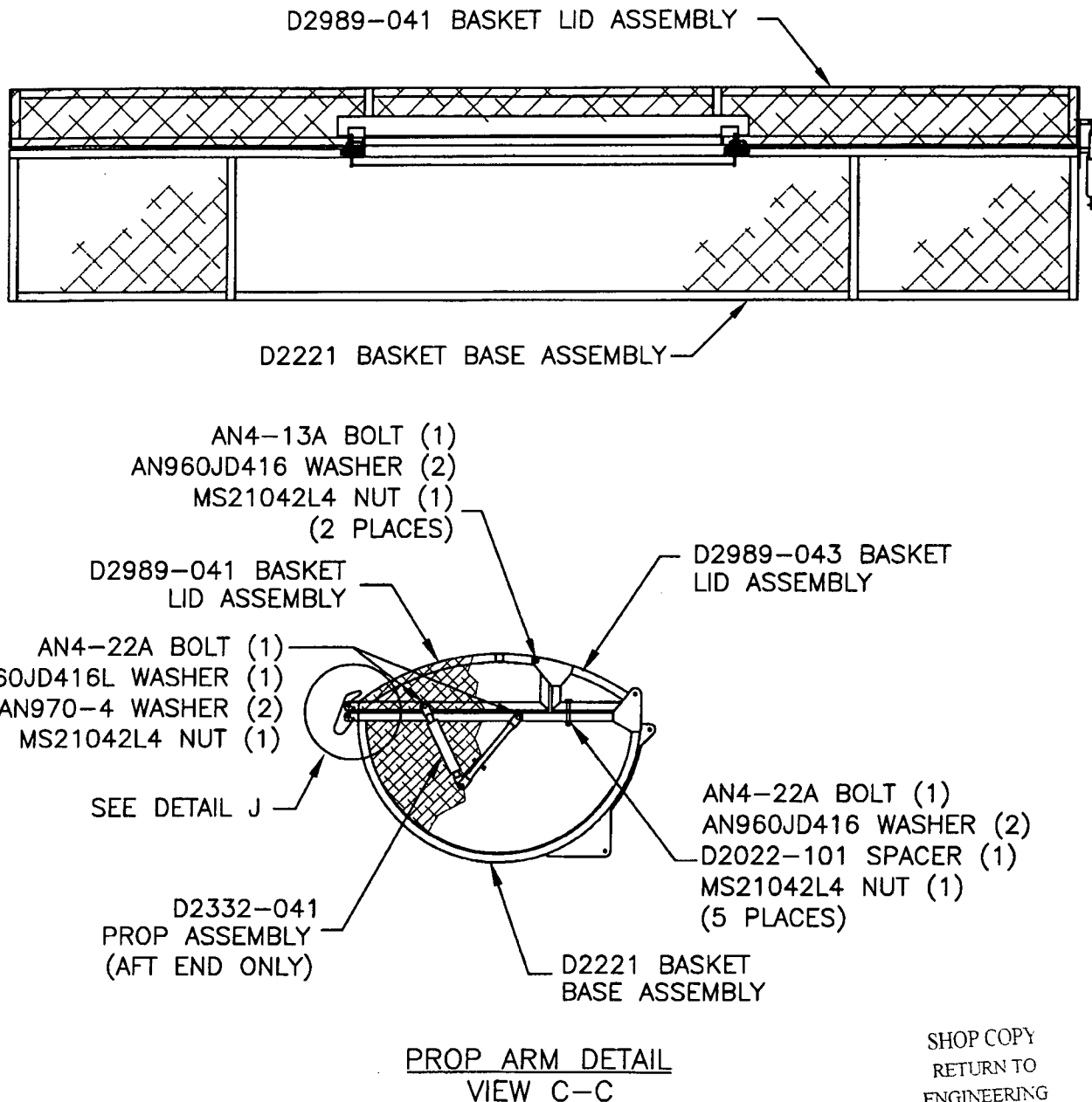
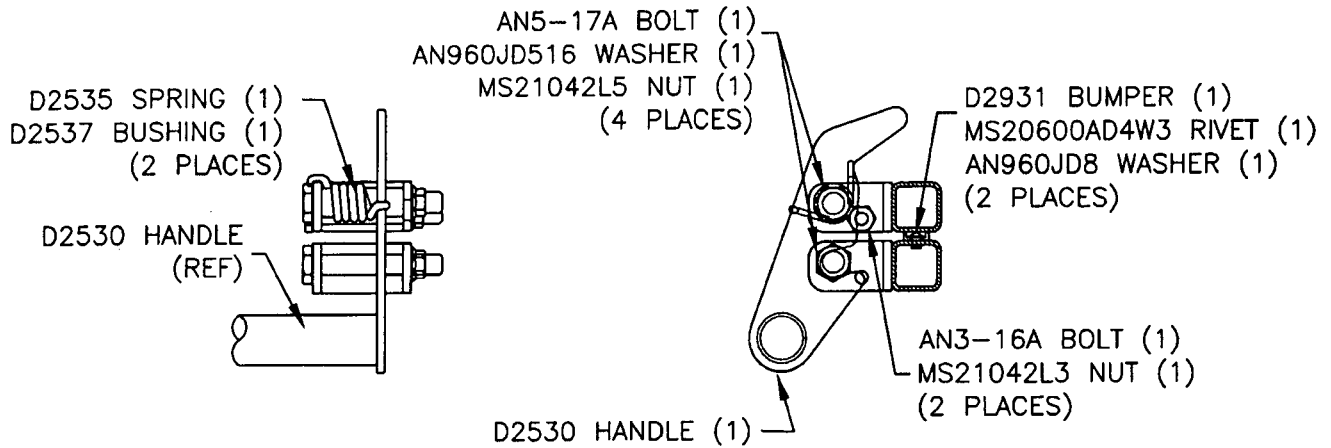


Figure 5- Basket Replacement Parts
(D350-607-043 Heli-Utility-Basket™)

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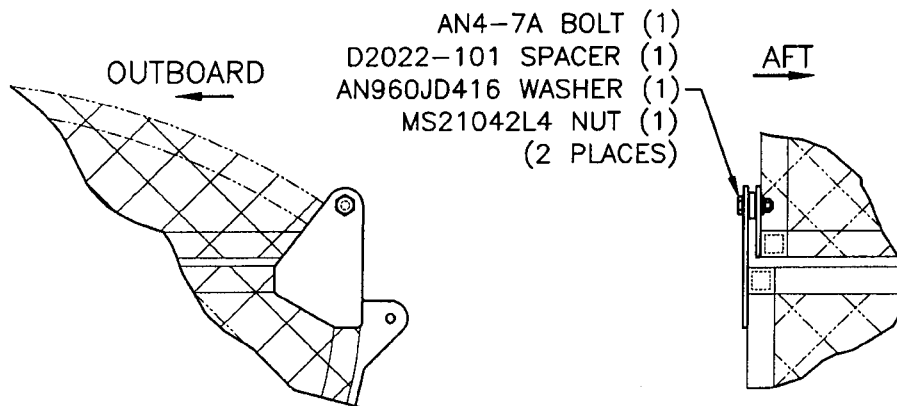
Revision: **F**
Date: 03.01.17



SPRING DETAIL

LATCH DETAIL

DETAIL J:
HANDLE WELDMENT



HINGE DETAIL
END VIEW, LOOKING AFT
OTHER END OPPOSITE

HINGE DETAIL
SIDE VIEW, LOOKING OUTBOARD.
OTHER END OPPOSITE

DETAIL H:
HINGE

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Figure 6 – Basket Replacement Parts

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Revision: F
Date: 03.01.17



| | | | |
|-------------------------------|--------------------------------|---|------------------------|
| DESIGN <i>CP</i> | DRAWN BY <i>CP</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. DSI 9318 | REV. A SHEET 1 OF 1 |
| DATE 06.01.06 | | TITLE WASHER ADDITION | SCALE NTS |
| A | 06.01.06 | NEW ISSUE | |

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-607 REV. F

REF. CANADIAN STC: SH94-14 ISSUE 4

REF. FAA STC: SR00213NY

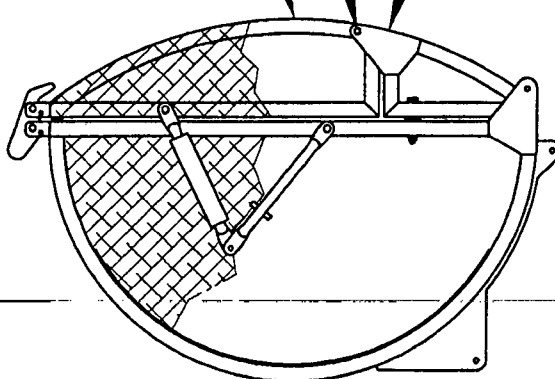
To reduce the possibility of damaging the finish, a **NAS1515H4** washer (2 places) has been added between the hinge plate and basket frame on the **D350-607-043/-047 Heli-Utility-Basket**.

The corrected bolt stackup from Figure 5 of installation instructions D350-607 Rev. F is given below:

AN4-13A BOLT (1)
AN960JD416 WASHER (1)
HINGE PLATE (REF)
NAS1515H4 WASHER (1)
BASKET FRAME (REF)
AN960JD416 WASHER (1)
MS21042L4 NUT (1)
(2 PLACES)

BASKET FRAME (REF)

HINGE PLATE (REF)



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35436

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE #02)

DATE: 06.01.06
CERT. NO.: SH94-14
ISSUE NO.: 4

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Date: Wednesday, 11/21/2007 12:50:58 PM
 User: Kim Johnston

Process Sheet

49

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : UTILITY BASKET LHRH
 Job Number : 35936
 Estimate Number : 10236
 P.O. Number :
 This Issue : 11/21/2007 S.O. No. :
 Prsht Rev. : NC Part Number : D350607047
 First Issue : 11 Type : LARGE FAB ASSY Drawing Number : D350-607 REV F
 Previous Run : 31265 Drawing Revision : F
 Written By : Due Date : 12/6/2007 Qty: 1 Um: Each
 Checked & Approved By :
 Comment : Est Rev:B Re-Format 05-11-03 JLM
 Est Rev:C As per DSI9318 06-09-05 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPPD350-607-047 CHG001

+DSI9380 Rev.B KIT

002

07.11.21

2.0 35936A 350 BASKET BASE (SHORT)



Comment: Sub-Component 350 BASKET BASE (SHORT)

D3265-041 B_____

3.0 35936B BASKET LID ASSEMBLY



Comment: Sub-Component BASKET LID ASSEMBLY

D3267-043 B_____

4.0 35936C BASKET LID ASSEMBLY



Comment: Sub-Component BASKET LID ASSEMBLY

D3267-041 B_____

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick: Assembly Kit

REFERENCE ONLY

6.0 D2022101 Spacer



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Spacer

Batch: _____

ENGINEERING CHANGE NOTICE

DART AEROSPACE LTD

| | | | | |
|-----------------------------------|----------------|---|---------------------------|-------------|
| Date: 07.11.15 | Job No.: 00056 | ADR Yes/No: <input checked="" type="checkbox"/> N | ADR Date: <i>MD</i> | ECN #: 1068 |
| Product No.: D350-607 | | Created By: <i>MD</i> | Approved By: <i>MD</i> | |
| Product Name: HELI-UTILITY-BASKET | | Checked By: <i>MD</i> | General Manager Approval: | |

| Distribution | Reqd | Resp | Received |
|------------------------------|------|-------|-----------|
| Production Manager | X | LL | <i>MD</i> |
| Production Engineering Coord | X | EC/DD | <i>MD</i> |
| Director Quality Assurance | | | |
| Customer Order Processing | | | |

| Distribution | Reqd | Resp | Received |
|-----------------------------|------|-------|--------------------|
| Customer Technical Support | X | DSTOW | <i>MD 07.11.19</i> |
| Marketing | X | SW | <i>MD 07.11.19</i> |
| Quality Control Coordinator | X | JM | <i>MD 07.11.19</i> |

Reason for Change:
INCLUDE D2732-030 RUBBER CUSHIONS AS STANDARD ON D350-607-041/-043/-045/-047 HELI-UTILITY BASKETS

Documents Affected:
RELEASE: DSI 9380 REV B

| # | Engineering Actions | Reqd | Resp | Notes | Complete |
|----|--|------|------|---|--------------------|
| 1 | Required Documents/Drawings Under Review | N | | | |
| 2 | Update Blue/Pink/DSI Folder and Electronic Files | Y | KJ | DSI 9380 REV. B WILL SUPERCEDE REV. A. | <i>07.11.19 MD</i> |
| 3 | Update D-Part/M-Drawing/DSI/DEO Master Binders | Y | KJ | | <i>07.11.19 MD</i> |
| 4 | Update Grey Project Binder | Y | KJ | | <i>07.11.19 MD</i> |
| 5 | Move Electronic Files | Y | KJ | | <i>07.11.16 MD</i> |
| 6 | Update Master Document List (MDL) | N | | | |
| 7 | Update Document Record (DR) <i>Rev. P</i> | Y | KJ | | <i>07.11.20 MD</i> |
| 8 | Create/Update Change Record Form | Y | KJ | SEE DSI 9380 REV. B FOR NEW CHANGE NUMBER | <i>07.11.20 MD</i> |
| 9 | Create/Update PPP's | Y | KJ | SEE ITEM #8 + 607-041/043/045/047 | <i>07.11.20 MD</i> |
| 10 | Update Controlled PDF Files | Y | KJ | | <i>07.11.19 MD</i> |
| 11 | Notify TC/FAA of Change | N | | | |
| 12 | Update QSI 021 and/or STC Approval List | N | | | |
| 13 | Update Product Development Summary | N | | | |
| 14 | Update Accpac Database | N | | | |
| 15 | Update Access (ARC) Database | N | | | |
| 16 | Update/Verify ARC | N | | | |
| 17 | Update Paperwork Kits in Production | Y | KJ | ONLY IF KITS HAVE BEEN REWORKED PER DSI | <i>07.11.20 MD</i> |
| 18 | Update Qpulse/Laminated Dwgs | N | | <i>LD SEE ATTACHED FOR BATCHES.</i> | |
| 19 | Update Product Compatibility Matrix | N | | | |
| 20 | Create Eurocopter Form (FEE) | N | | | |
| 21 | | | | | |

| # | Production Actions | Reqd | Resp | Notes | Complete |
|----|--|------|-------|---|-----------------------|
| 22 | Create/Update Coss IPP/BOM | Y | EC/DD | AMEND PICK LIST PER DSI 9380 REV. B | <i>MD 08/01/08</i> |
| 23 | Update FAI Sheets | N | | | |
| 24 | Create/Update CNC Programs | N | | | |
| 25 | Create/Update Tooling | N | | | |
| 26 | Red Tag Stock (Specify) | Y | JM | RED TAG STOCK WITH OLD CHANGE # | <i>MD 07.11.19</i> |
| 27 | Rework/Scrap Current Production and/or Stock | Y | LL | ADD/REMOVE PARTS PER DSI | <i>MD 07.11.21 MD</i> |
| 28 | Update Paperwork Kits in Stock | Y | LL | ONLY IF KITS HAVE BEEN REWORKED PER DSI | <i>MD 07.11.21 MD</i> |
| 29 | Create/Update MPP | N | | | |
| 30 | | | | | |

| # | Quality Assurance Actions | Reqd | Resp | Notes | Complete |
|----|---------------------------|------|------|------------|----------|
| 31 | Notify Previous Customers | Y | SW | NOTIFY DHS | |
| 32 | Notify Eurocopter France | N | | | |
| 33 | | | | | |

Description / Action:
UPDATE ALL KITS IN STOCK ASAP.
D350-607-041/-043/-045/047 GO UP A CHG# 007/004/002/002 RESPECTIVELY

DART SERVICE INSTRUCTION

TO AMEND DRAWING D350-607 REV. F

REF CANADIAN STC: SH94-14

FAA STC: SR00213NY

FOR THE FOLLOWING D350-607-XXX HELI-UTILITY-BASKET INSTALLATIONS, INSTALL THE D2732-030 RUBBER CUSHIONS UNDER THE D2230-1/-3 CLAMPS AS SHOWN IN FIGURE 1. THE D2856-400-720 ABRASION STRIPS HAVE BEEN REMOVED FROM THE D350-607-XXX HELI-UTILITY-BASKET KITS.

TABLE 1: D350-607-XXX KITS WITH D2732-030 RUBBER CUSHION

| INSTALLATION | CHG NUMBER |
|--------------|--------------|
| D350-607-041 | 007 OR LATER |
| D350-607-043 | 004 OR LATER |
| D350-607-045 | 002 OR LATER |
| D350-607-047 | 002 OR LATER |

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 35936

AMEND PARTS LIST AS FOLLOWS:

REMOVE:




| Qty -041 | Qty -043 | Qty -045 | Qty -047 | PART NUMBER | DESCRIPTION |
|-------------|-------------|-------------|-------------|---------------|---------------------|
| X | | | | D350-607-041 | HELI-UTILITY-BASKET |
| | X | | | D350-607-043 | HELI-UTILITY-BASKET |
| | | X | | D350-607-045 | HELI-UTILITY-BASKET |
| | | | X | D350-607-047 | HELI-UTILITY-BASKET |
| 4 | 4 | 4 | 4 | D2856-400-720 | ABRASION STRIP |
| 8 | 8* | 8 | 8* | AN4-13A | BOLT |

*NOTE: FOR D350-607-043/-047 INSTALLATIONS, QTY (2) AN4-13A BOLTS USED FOR INSTALLATION OF THE SPLIT LID ARE STILL INCLUDED

ADD:

| Qty -041 | Qty -043 | Qty -045 | Qty -047 | PART NUMBER | DESCRIPTION |
|-------------|-------------|-------------|-------------|--------------|---------------------|
| X | | | | D350-607-041 | HELI-UTILITY-BASKET |
| | X | | | D350-607-043 | HELI-UTILITY-BASKET |
| | | X | | D350-607-045 | HELI-UTILITY-BASKET |
| | | | X | D350-607-047 | HELI-UTILITY-BASKET |
| 8 | 8 | 8 | 8 | D2732-030 | RUBBER CUSHION |
| 8 | 8 | 8 | 8 | AN4-15A | BOLT |

| |
|---|
| CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01 |
| APPROVED  |
| BY: <u>D. SHEPHERD (DE # 02)</u> |
| DATE: <u>07.11.14</u> |
| CERT. NO.: <u>SH94-14</u> |
| ISSUE NO.: <u>4</u> |

| | | | |
|------------|--|--|--------------|
| B | D2732-030 IS NOW STANDARD ON -041/-043/-045/-047; DSI 9380-011 UPGRADE OPTION FOR PREVIOUS CUSTOMERS | PH | 07.11.14 |
| A | NEW ISSUE | MB | 07.06.06 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN |  | DART AEROSPACE LTD | |
| DRAWN |  | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED |  | DRAWING NO. | REV. B |
| MFG. APPR. | N/A | DSI 9380 | SHEET 1 OF 2 |
| APPROVED |  | TITLE | SCALE |
| DE APPR. |  | RUBBER CUSHION KIT | NTS |
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49

Date: Wednesday, 11/21/2007 12:51:06 PM
 User: Kim Johnston

Process Sheet

| | |
|--|--|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : 350 BASKET BASE (SHORT) |
| Job Number : 35936A | |
| Estimate Number : 10209 | |
| P.O. Number : | Part Number : D3265041 |
| This Issue : 11/21/2007 S.O. No. : | Drawing Number : D3265 REV B |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : / / Type : LARGE FAB ASSY | Drawing Revision : B |
| Previous Run : 35904A | Material : |
| Written By : | Due Date : 12/6/2007 Qty: 1 Um: Each |
| Checked & Approved By : <u>[Signature]</u> | |
| Comment : Est Rev:0 Re-Format 05-11-03 JLM | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|--------|-------------|
| 1.0 | D31661 | Basket Hoop |
|-----|--------|-------------|



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)
 Qty 3 D3166-1 Basket Hoop Batch: B36457

J.J.L. 08/01/08

| | | |
|-----|----------------|--------------------------|
| 2.0 | M304TS0750W065 | 304 SQ Tube.75x.75x.065W |
|-----|----------------|--------------------------|



Comment: Qty.: 19.2150 f(s)/Unit Total : 19.2150 f(s)
 3/4" x 3/4" x 0.063" wall 304/316 SS tubing.
 (M304TS0.750W.065)
 Batch: m 106367

J.J.L. 08/01/08

| | | |
|-----|--------|--------------|
| 3.0 | D22323 | Basket Hinge |
|-----|--------|--------------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Pick:
 Qty Part Number Description Batch
 2 D2232-3 Hinge bracket B 35354

J.J.L. 08/01/08

| | | |
|-----|-------|--------------------------|
| 4.0 | D2325 | Support Gusset (350 Bask |
|-----|-------|--------------------------|



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
 Pick:
 Qty Part Number Description Batch
 4 D2325 Support Gusset B 35584

J.J.L. 08/01/08

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Wednesday, 11/21/2007 12:51:06 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 BASKET BASE (SHORT)

Job Number: 35936A

Part Number: D3265041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D23273

Spacer Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

J.J.L. 08/01/08

Pick:

Qty Part Number

Description Batch

2 D2327-3

Bushing

B 34589

6.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

J.J.L. 08/01/08

Pick:

Qty Part Number

Description Batch

2 D2581

Mounting Bracket

B 34509

7.0

D34425

Shim



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

J.J.L. 08/01/08

Pick:

Qty Part Number

Description Batch

2 D3442-5

Shim

B 33282

8.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 26.0000 sf(s)/Unit Total : 26.0000 sf(s)

J.J.L. 08/01/16

Pick:

Qty Part Number

Description

Batch

26sf

M304EX0.75-16F

Expanded Metal

M 106443

*

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

J.J.L. 08/01/17

1-CUT (3) D2235-1 FROM D3166-1

2-Drill hole in D3265-3 as per Dwg D3265

3-Remove all markings from material

4-Weld as per Dwg D3265 using Welding Table and corner JigDeburr as required

PRW

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: D3265-041 PAR #: N/A Fault Category: PROD - LG. FAB NCR: Yes No DQA: AS Date: 08.01.25
 QA: N/C Closed: AS Date: 08.01.28

| NCR: <u>35936A</u> | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|--------------------|------------|---|---------------------------------------|--|---------------------------------------|---------------------------------------|---------------------------------------|---------------------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| <u>08-01-17</u> | <u>9.0</u> | <u>The 27.63 hole was drilled on the base from the opposite side.</u> | <u>[Signature]</u> <u>08/01/17</u> | <u>Part is acceptable. The hole is on the opposite side of the center rib. This time only.</u> | <u>[Signature]</u> <u>08-01-17</u> | <u>[Signature]</u> <u>08-01-17</u> | <u>[Signature]</u> <u>08/01/17</u> | <u>[Signature]</u> <u>08-01-17</u> |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Wednesday, 11/21/2007 12:51:06 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 BASKET BASE (SHORT)

Job Number: 35936A

Part Number: D3265041

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-01-17 ①

11.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

PD 08-01-17 ①

12.0

POWDER COATING

POWDER COATING



M 106379



(1X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m-l 08/01/22

13.0

HAND FINISHING

HAND FINISHING RESOURCE #1

GA



Comment: HAND FINISHING RESOURCE #1

Seal support gusset seam with White Sikaflex-291

Batch: M105585

Expiry date: 07/2008

m 08/01/23

(X1)

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

m 08/01/23

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: PPP 35936

8/6/24

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08.01.25

Job Completion



2008/1/24

W

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



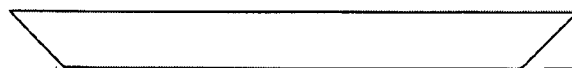
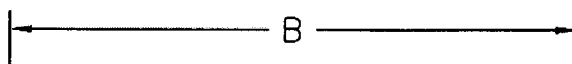
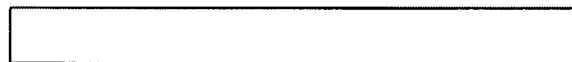
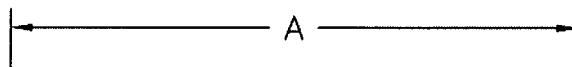
| | | | |
|------------------|----------------|---|------------------------|
| DESIGN DS | DRAWN BY PH | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED # | APPROVED # | DRAWING NO. D3265 | REV. B SHEET 1 OF 3 |
| DATE 05.06.08 | | TITLE BASKET BASE ASSEMBLY (350) | SCALE NTS |
| A | 04.02.02 | NEW ISSUE | |
| B | 05.06.08 | ADD SHIM UNDER HINGES, ADD HOLES FOR SPLIT LID BASKETS | |

RELEASED

05.08.19

PARTS LIST FOR D3265-041 BASKET BASE ASSEMBLY

| PART NO | QUANTITY | LENGTH A | LENGTH B | DESCRIPTION |
|---------|----------|-------------|-------------|----------------|
| D3265-1 | 2 | — | 56.75↓ | RIB |
| D3265-3 | 2 | — | 25.50↓ | RIB |
| D3265-5 | 2 | 27.25↓ | — | RIB |
| D2232-3 | 2 | N/A | N/A | HINGE PLATE |
| D2235-1 | 4 | N/A | N/A | RIB |
| D2325 | 4 | N/A | N/A | SUPPORT GUSSET |
| D2327-3 | 2 | N/A | N/A | BUSHING |
| D2581 | 2 | N/A | N/A | MTG BRKT |
| D3442-5 | 2 | N/A | N/A | SHIM |



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NO. 35936A

D3265-1/-3/-5

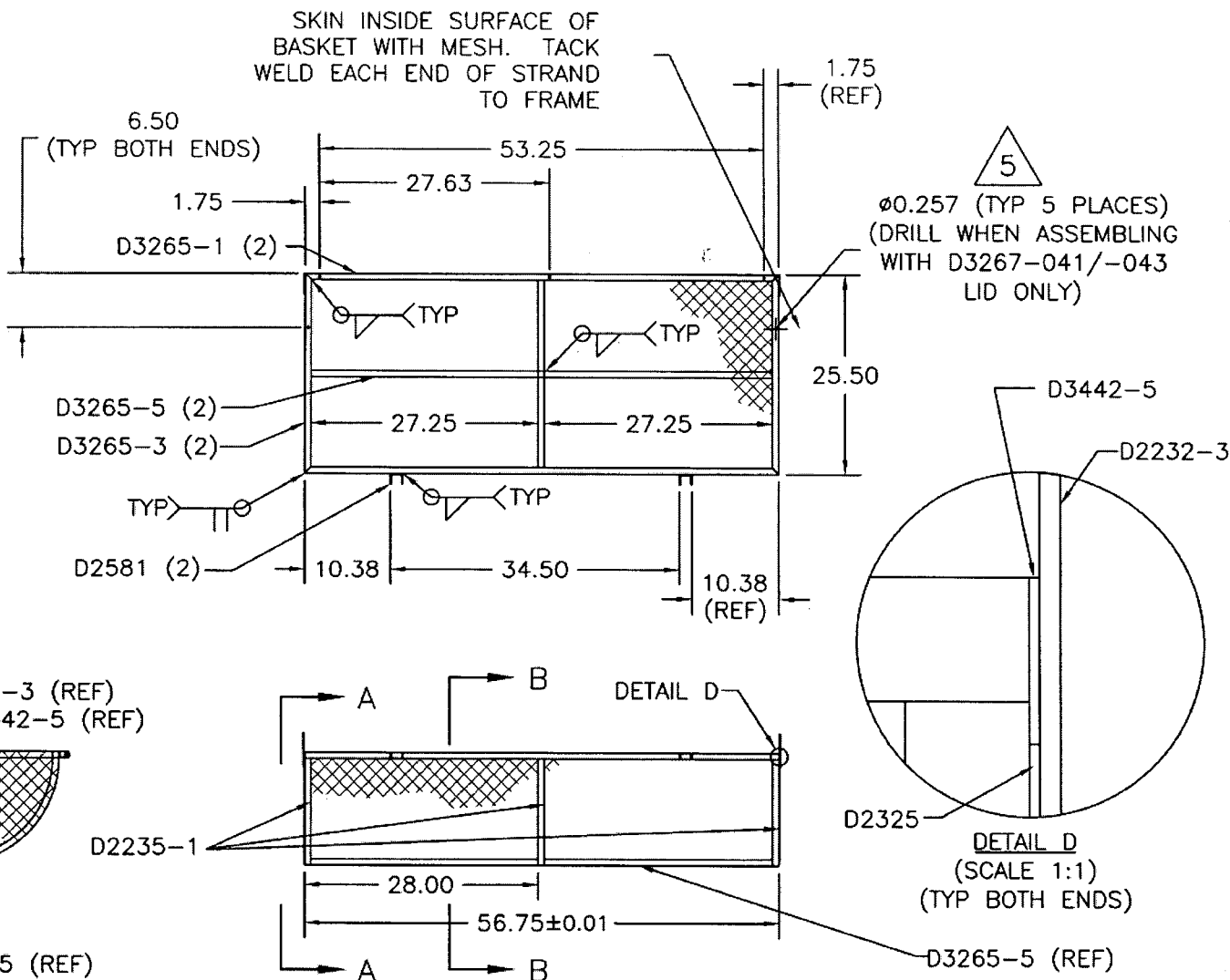
- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING
(REF. DART SPEC M304TS0.750W.060)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) DRILL $\phi 0.257$ HOLES ONLY WHEN ASSEMBLING
D3265-041 BASE WITH D3267-041/-043 LID

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|----------|----------------------------|-----------------------------|
| DS | PH | HAWKESBURY, ONTARIO, CANADA |
| CHECKED | APPROVED | DRAWING NO. |
| | | D3265 |
| DATE | TITLE | REV. B |
| 05.06.08 | BASKET BASE ASSEMBLY (350) | SHEET 2 OF 3 |
| | | SCALE 1:20 |



D3265-041 BASKET BASE ASSEMBLY

MESH MATERIAL: 3/4-16F EXPANDED SS (REF DART SPEC M304EX0.75-16F)

WELD PER DART QSI 004

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3

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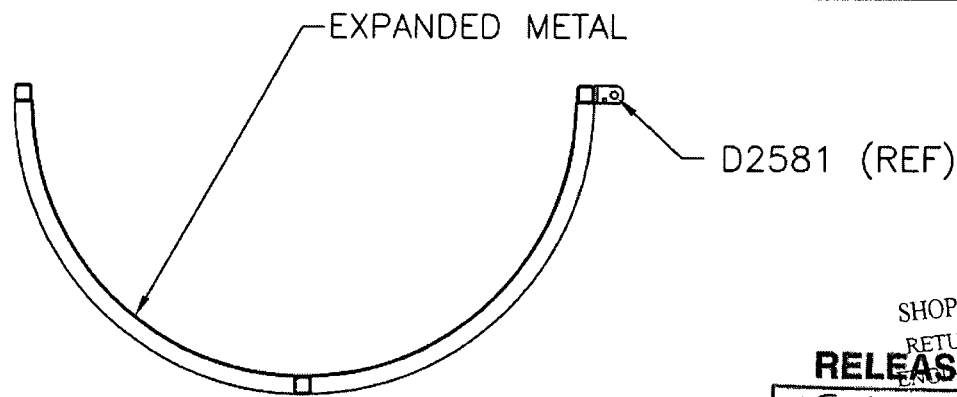
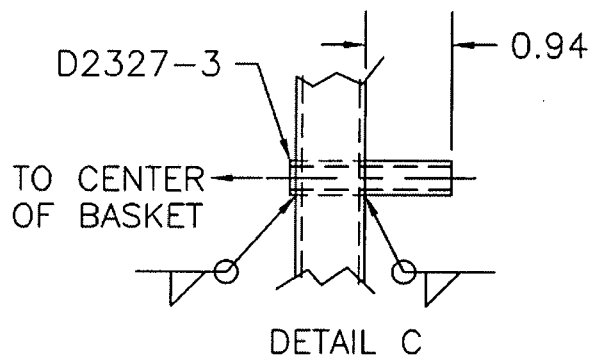
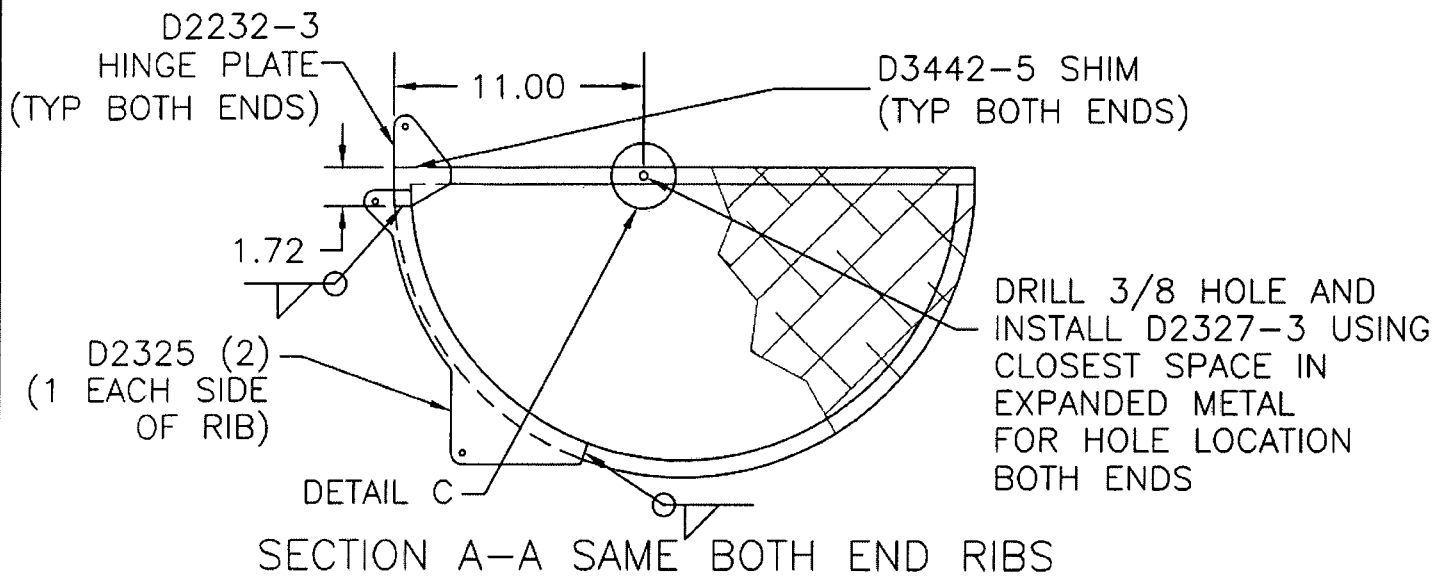
05.08.09

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|------------------------|-------------------------|---|------------------------|
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| CHECKED [Signature] | APPROVED [Signature] | DRAWING NO. D3265 | REV. B SHEET 3 OF 3 |
| DATE 05.06.08 | | TITLE BASKET BASE ASSEMBLY (350) | SCALE 1:8 |



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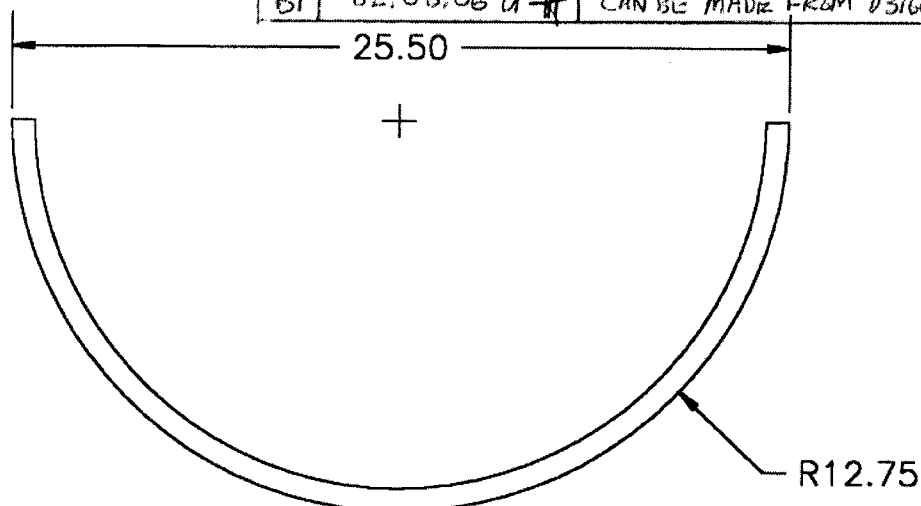
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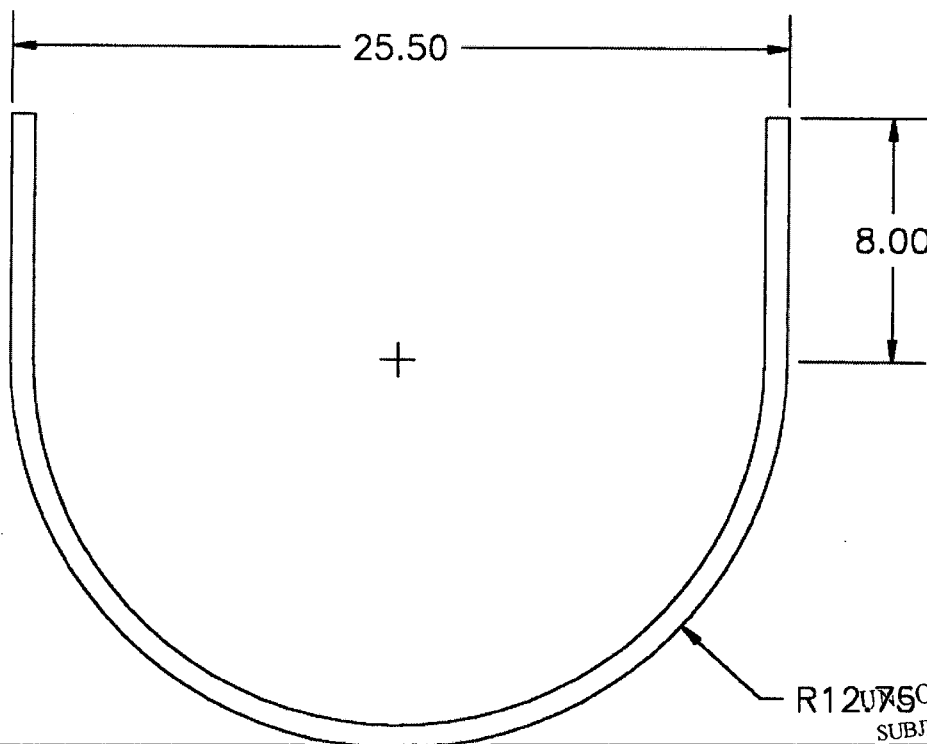


| | | | |
|------------|---------------|--|--------------|
| DESIGN | DRAWN BY | DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA | |
| B WILLIAMS | B WILLIAMS | DRAWING NO. | REV. B |
| CHECKED | APPROVED | D2235 | SHEET 1 OF 1 |
| DATE | | TITLE | SCALE |
| 94:12:16 | | BASKET RIBS | |
| BI | 02.08.06 UP-1 | CAN BE MADE FROM D3166-1 | |

RELEASED
R 960507



D2235-1



D2235-3

CAN BE MADE FROM D3166-1 BI
MATERIAL: 304/316 SS, 3/4 X 3/4 X 0.063 WALL SQR.

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WITHOUT NOTICE
WORK ORDER
NO. 35936A

49

Date: Wednesday, 11/21/2007 12:51:11 PM
 User: Kim Johnston

Process Sheet

| | |
|---|--------------------------------------|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : BASKET LID ASSEMBLY |
| Job Number : 35936B | |
| Estimate Number : 10226 | |
| P.O. Number : | Part Number : D3267043 |
| This Issue : 11/21/2007 S.O. No. : | Drawing Number : D3267 REV B |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : 1 / Type : LARGE FAB ASSY | Drawing Revision : B |
| Previous Run : 31265B | Material : |
| Written By : <u> </u> | Due Date : 12/6/2007 Qty: 1 Um: Each |
| Checked & Approved By : <u> </u> | |
| Comment : Est Rev:C Removed -041 05-11-04 JLM | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|----------------|--------------------------|
| 1.0 | M304TS0750W065 | 304 SQ Tube.75x.75x.065W |
|-----|----------------|--------------------------|



Comment: Qty.: 7.3500 f(s)/Unit Total : 7.3500 f(s)
 3/4" x 3/4" x 0.063" wall 304/316 SS tubing
 Batch: B 106367

J.J.L. 08/01/08

| | | |
|-----|--------|-------------|
| 2.0 | D31663 | Basket Hoop |
|-----|--------|-------------|



Comment: Qty.: 0.0000 Each(s)/Unit Total : 0.0000 Each(s)
 Qty 1 D3166-3 Basket Hoop
 Batch: B 35358 *
 Note: D3166-3 included in D3267-041 BOM

J.J.L. 08/01/08

| | | |
|-----|--------|-------|
| 3.0 | D31821 | Hinge |
|-----|--------|-------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Pick:
 Qty Part number Description Batch
 2 D3182-1 Hinge B 36483

J.J.L. 08/01/08

| | | |
|-----|--------|------|
| 4.0 | D34423 | Shim |
|-----|--------|------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Pick:
 Qty Part number Description Batch
 2 D3442-3 Shim B 26740

J.J.L. 08/01/08

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Wednesday, 11/21/2007 12:51:11 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASSEMBLY

Job Number: 35936B

Part Number: D3267043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 4.5150 sf(s)/Unit Total : 4.5150 sf(s)

J. J. L.

08/01/16

Pick:

Qty Part number

Description

Batch

4.300sf M304EX0.75-16F Expanded Metal

M106443

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

J. J. L.

08/01/17

1-Cut Rib from 3/4" x 3/4" x 0.063" wall 304/316 SS tubing as per Dwg D3267

2-Cut (4) D2236-1 From D3166-3

3-Drill holes in tubing D3267-043 as per Dwg D3267

4-Deburr & Remove All Markings From Material

5-Weld D3267-043 Assembly using Welding Table and corner Jig as per Dwg D3267. Deburr as required

Note: Expanded metal "diamonds" must run lengthwise. Eg 2.0" along length of lid.

7.0

QC9/6

DDIMENSIONAL & WELDING INSPECTION



Comment: DDIMENSIONAL & WELDING INSPECTION

PD

08-01-17

①

8.0

POWDER COATING

POWDER COATING



M106379



(IX)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M. J.

08/01/22

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(XI)

Comment: Inspect Powder Coat

m 08/01/23

10.0

QC21

FINAL INSPECTION/W/O RELEASE



08.01.25

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



2008/1/24
W

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

DART

| | | | |
|------------------|----------------|--|------------------------|
| DESIGN DS | DRAWN BY PH | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED # | APPROVED # | DRAWING NO. D3267 | REV. B SHEET 1 OF 2 |
| DATE 05.06.08 | | TITLE BASKET LID ASSEMBLY | SCALE NTS |
| A | 04.02.02 | NEW ISSUE | |
| B | 05.06.08 | ADD SHIM UNDER HINGES | |

RELEASED

05.08.19 #

PARTS LIST:

| Qty -041 | Qty -043 | Part Number | Description |
|-------------|-------------|-------------|-------------------------------|
| X | | D3267-041 | BASKET LID ASSEMBLY (OUTSIDE) |
| | X | D3267-043 | BASKET LID ASSEMBLY (INSIDE) |
| | 1 | D2989-1 | STRUT |
| | 1 | D2989-2 | STRUT |
| | 1 | D2989-3 | STRUT |
| | 1 | D2989-4 | STRUT |
| | 2 | D2989-5 | STRUT |
| | 2 | D2989-7 | STRUT |
| 1 | | D2989-9 | STRUT |
| 1 | | D2989-10 | STRUT |
| 1 | | D2989-11 | STRUT |
| 1 | | D2989-12 | STRUT |
| 2 | | D2989-13 | STRUT |
| 2 | | D2989-15 | STRUT |
| 2 | | D2327-3 | SPACER BUSHING |
| 1 | | D2506 | LABEL PLATE |
| 1 | | D2512-7 | STRUT |
| 2 | | D2581 | MOUNTING BRACKET |
| | 2 | D3182-1 | HINGE |
| 2 | 2 | D3265-3 | STRUT |
| 1 | | D3266-7 | STRUT |
| 2 | | D3267-1 | STRUT |
| | 2 | D3442-3 | SHIM |

NOTES:

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.060 WALL SQUARE TUBING
(REF. DART SPEC M304TS0.750W.060)
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS (REF. DART SPEC M304EX0.75-16F)
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3.
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4. SPRAY PAINT
INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID.
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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329361B

SKIN BASKET LID WITH 3/4-16F
EXPANDED SS, TACK WELD EACH
END STRAND TO EXTERNAL FRAME

D2506 LABEL PLATE
CENTER ON THE BASKET

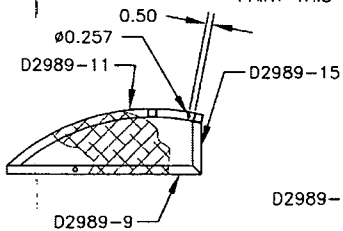
REMOVE 2" x 6" SECTION
OF MESH FROM BEHIND
LABEL PLATE

SEE DETAIL C
(TYPICAL 2 PLACES)

TACK WELD EVERY
2ND STRAND TO
INTERNAL FRAME
MEMBERS

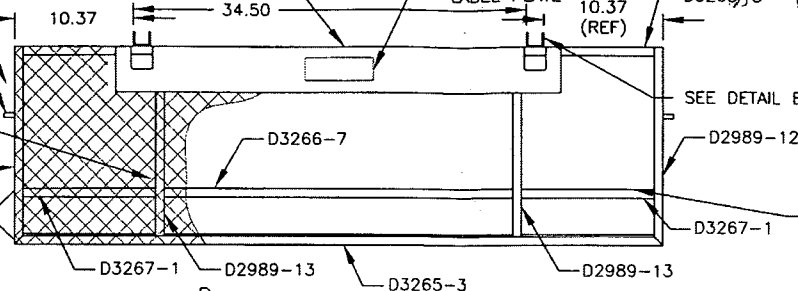
D2989-11 (REF)

BLACK ANTI-SKID
PAINT THIS SECTION



RELEASED

05-08-19



D3267-041 LID ASSEMBLY

SEE DETAIL A

TACK WELD EVERY 2ND
STRAND TO INTERNAL
FRAME MEMBERS

D2989-3 (REF)

D3265-3

D2989-4

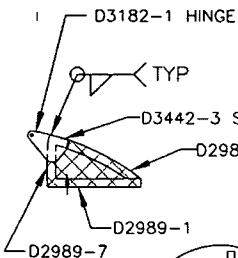
0.257 (TYP 5 PLACES)

D3265-3

D2989-5

D2989-5

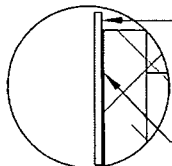
SKIN BASKET LID WITH 3/4-16F
EXPANDED SS, TACK WELD EACH
END STRAND TO EXTERNAL FRAME



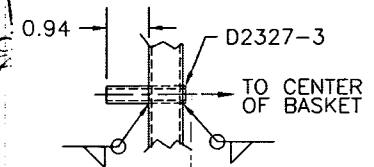
DETAIL E

DETAIL E
(SCALE 1:2)
(TYP BOTH ENDS)

D3442-3 SHIM

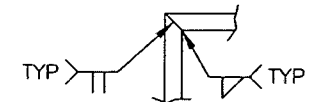
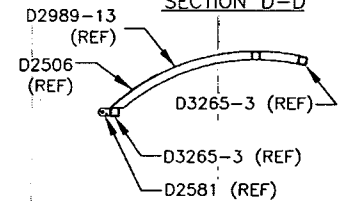


D3267-043 LID ASSEMBLY

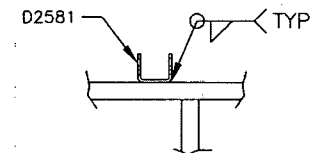


DETAIL C
SPACER INSTALLATION

SECTION D-D



DETAIL A
WELD ALL JOINTS
AS SHOWN

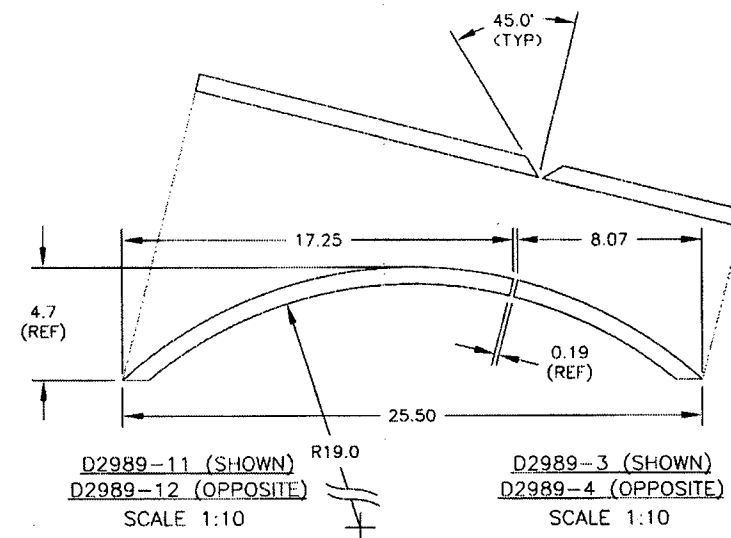
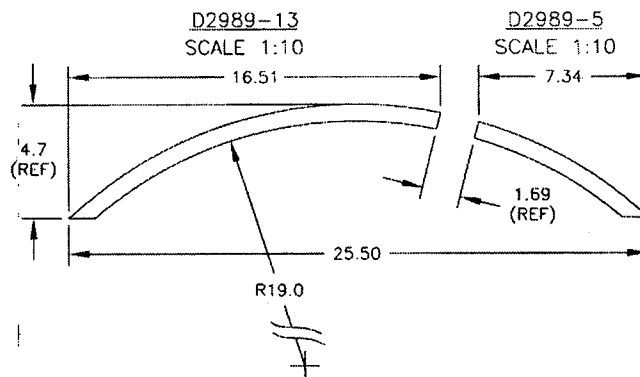


DETAIL B

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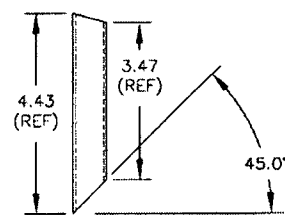
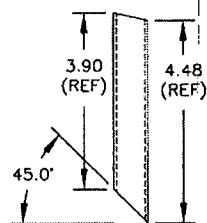
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| DESIGN | DS | DRAWN BY | PH | DART | DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA |
| CHECKED | <i>[Signature]</i> | APPROVED | <i>[Signature]</i> | DRAWING NO. D3267 | REV. B SHEET 2 OF 2 |
| DATE | 05.06.08 | TITLE | BASKET LID ASSEMBLY | SCALE | 1:10 |

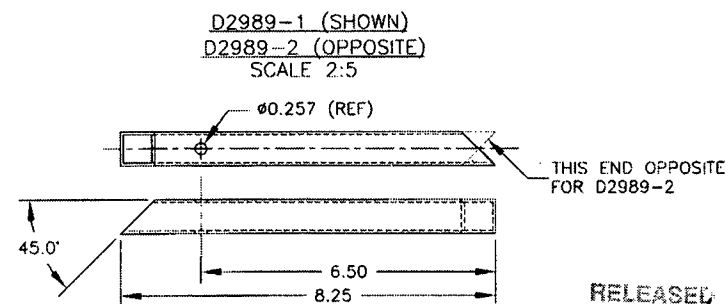
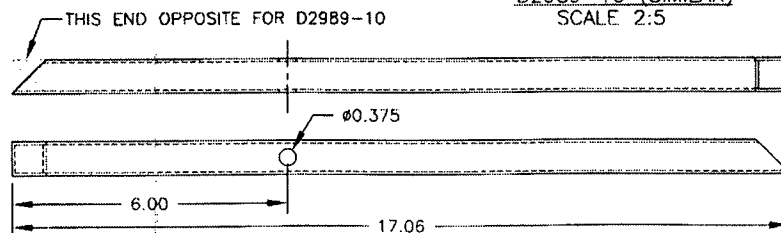


D2989-15
SCALE 2:5
(DIMENSIONS LISTED AS REFERENCE ONLY, CUT TO FIT ASSEMBLY)

D2989-7
SCALE 2:5
(DIMENSIONS LISTED AS REFERENCE ONLY, CUT TO FIT ASSEMBLY)



D2989-9 (SHOWN)
D2989-10 (SIMILAR)
SCALE 2:5



RELEASED

05.08.19

| | | | | | |
|--|--|----------|----------|---------------------|--|
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| | | CHECKED | APPROVED | DRAWING NO. | REV. B |
| | | | | D2989 | SHEET 3 OF 3 |
| | | DATE | | TITLE | SCALE |
| | | 05.06.07 | | BASKET LID ASSEMBLY | 1:10 |

W10: 35936C
C208/01108

Date: Wednesday, 11/21/2007 12:51:17 PM
 User: Kim Johnston

Process Sheet

49

| | | | |
|-------------------------|-------------------------------------|--------------------|---------------------------|
| Customer : | CU-DAR001 Dart Helicopters Services | Drawing Name : | BASKET LID ASSEMBLY |
| Job Number : | 35936C | | |
| Estimate Number : | 10212 | | |
| P.O. Number : | | Part Number : | D3267041 |
| This Issue : | 11/21/2007 S.O. No. : | Drawing Number : | D3267 REV B |
| Prsht Rev. : | NC | Project Number : | N/A |
| First Issue : | / / Type : LARGE FAB ASSY | Drawing Revision : | B |
| Previous Run : | 31265C | Material : | |
| Written By : | | Due Date : | 12/6/2007 Qty: 1 Um: Each |
| Checked & Approved By : | <u>11/21/07</u> | | |
| Comment : | Est Rev:0 Removed -043 05-11-04 JLM | | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|----------------|--------------------------|
| 1.0 | M304TS0750W065 | 304 SQ Tube.75x.75x.065W |
|-----|----------------|--------------------------|



Comment: Qty.: 32.1300 f(s)/Unit Total : 32.1300 f(s)
 3/4" x 3/4" x 0.063" wall 304/316 SS tubing
 Batch: m 106367

J.J.L. 08/01/08

| | | |
|-----|--------|-------------|
| 2.0 | D31663 | Basket Hoop |
|-----|--------|-------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Qty 1 D3166-3 Basket Hoop *
 Batch: B 35358

J.J.L. 08/01/08

| | | |
|-----|--------|----------------|
| 3.0 | D23273 | Spacer Bushing |
|-----|--------|----------------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Pick:
 Qty Part number Description Batch
 2 D2327-3 Bushing B 34589

J.J.L. 08/01/08

| | | |
|-----|-------|---------|
| 4.0 | D2506 | Placard |
|-----|-------|---------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Pick:
 Qty Part number Description Batch
 1 D2506 Label Plate B 33449 *

J.J.L. 08/01/08

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Wednesday, 11/21/2007 12:51:17 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASSEMBLY

Job Number: 35936C

Part Number: D3267041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

J.J.L. 08/01/08

Pick:

Qty Part number

Description

Batch

2 D2581

Mounting Brackets

B34507

6.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 8.1900 sf(s)/Unit Total : 8.1900 sf(s)

J.J.L. 08/01/16

Pick:

Qty Part number

Description

Batch

7.8sf

M304EX0.75-16F Expanded Metal

M106443

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

J.J.L. 08/01/16

1-Cut Rib from 3/4" x 3/4" x 0.063" wall 304/316 SS tubing as per Dwg D3267

2-Cut (4) D2236-1 From D3166-3

3-Drill holes in tubing D3267-041 as per Dwg D3267

4-Deburr & Remove All Markings From Material

5-Weld D3267-041 Assembly using Welding Table and corner Jig as per Dwg D3267. Deburr as required

Note: Expanded metal "diamonds" must run lengthwise.Eg 2.0" along length of lid.

6-Drill Ø0.257" hole in D3267-041 as per Dwg D3267/Identify as D3267-041

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-01-17 (1)

9.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

PD 08-01-17

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Wednesday, 11/21/2007 12:51:17 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASSEMBLY

Job Number: 35936C

Part Number: D3267041

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

POWDER COATING

POWDER COATING



M 106379



(1X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m-l

08/01/22

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing walk as per Dwg D3267 and QSI 005 4.4

Spray Paint Black: ~~m-10388~~ m/106388

Wing Walk: m/106332

Fol

08/01/22

(1)

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(1)

Comment: Inspect Powder Coat and Wing Walk

m/08/01/23

13.0

QC21

FINAL INSPECTION/W/O RELEASE



08.01.25

18

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



m/2008/1/24

U

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



| | | | |
|------------------|----------------|---|------------------------|
| DESIGN DS | DRAWN BY PH | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | APPROVED | DRAWING NO. D3267 | REV. B SHEET 1 OF 2 |
| DATE 05.06.08 | | TITLE BASKET LID ASSEMBLY | SCALE NTS |
| A | 04.02.02 | NEW ISSUE | |
| B | 05.06.08 | ADD SHIM UNDER HINGES | |

RELEASED

05-08-19

PARTS LIST:

| Qty -041 | Qty -043 | Part Number | Description |
|-------------|-------------|-------------|-------------------------------|
| X | | D3267-041 | BASKET LID ASSEMBLY (OUTSIDE) |
| | X | D3267-043 | BASKET LID ASSEMBLY (INSIDE) |
| | 1 | D2989-1 | STRUT |
| | 1 | D2989-2 | STRUT |
| | 1 | D2989-3 | STRUT |
| | 1 | D2989-4 | STRUT |
| | 2 | D2989-5 | STRUT |
| | 2 | D2989-7 | STRUT |
| 1 | | D2989-9 | STRUT |
| 1 | | D2989-10 | STRUT |
| 1 | | D2989-11 | STRUT |
| 1 | | D2989-12 | STRUT |
| 2 | | D2989-13 | STRUT |
| 2 | | D2989-15 | STRUT |
| 2 | | D2327-3 | SPACER BUSHING |
| 1 | | D2506 | LABEL PLATE |
| 1 | | D2512-7 | STRUT |
| 2 | | D2581 | MOUNTING BRACKET |
| | 2 | D3182-1 | HINGE |
| 2 | 2 | D3265-3 | STRUT |
| 1 | | D3266-7 | STRUT |
| 2 | | D3267-1 | STRUT |
| | 2 | D3442-3 | SHIM |

NOTES:

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.060 WALL SQUARE TUBING
(REF. DART SPEC M304TS0.750W.060)
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS (REF. DART SPEC M304EX0.75-16F)
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3.
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4. SPRAY PAINT
INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID.
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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 NO.

SKIN BASKET LID WITH 3/4-16F EXPANDED SS, TACK WELD EACH END STRAND TO EXTERNAL FRAME

D2506 LABEL PLATE CENTER ON THE BASKET

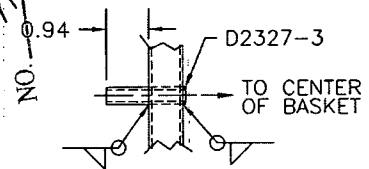
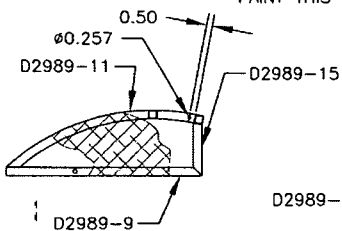
REMOVE 2" x 6" SECTION OF MESH FROM BEHIND LABEL PLATE

SEE DETAIL C (TYPICAL 2 PLACES)

TACK WELD EVERY 2ND STRAND TO INTERNAL FRAME MEMBERS

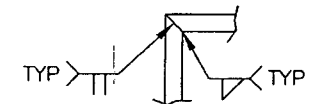
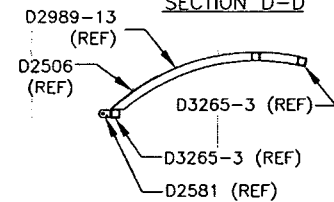
D2989-11 (REF)

BLACK ANTI-SKID PAINT THIS SECTION

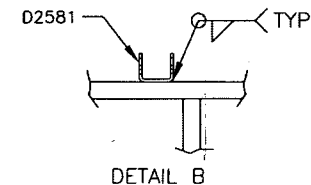


DETAIL C
SPACER INSTALLATION

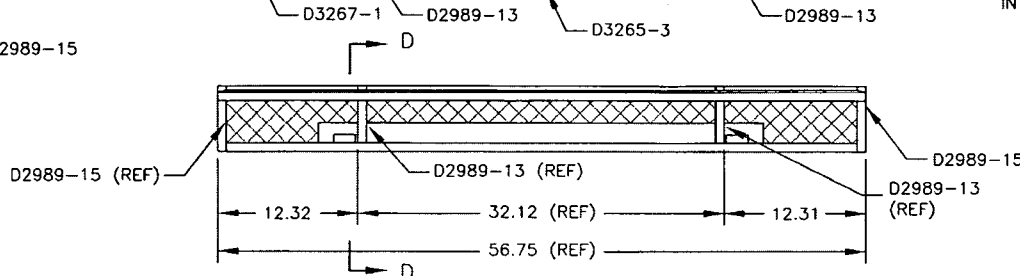
SECTION D-D



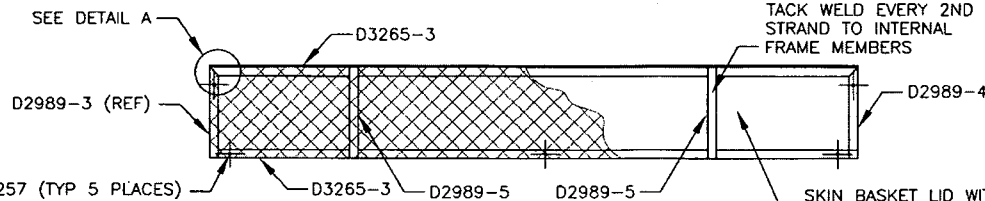
DETAIL A
WELD ALL JOINTS AS SHOWN



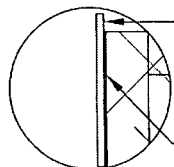
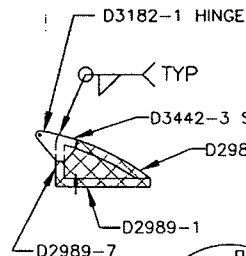
DETAIL B



D3267-041 LID ASSEMBLY



D3267-043 LID ASSEMBLY



DETAIL E
(SCALE 1:2)
(TYP BOTH ENDS)

D3442-3 SHIM

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| CHECKED | # | APPROVED | # | DRAWING NO. | REV. B |
| DATE | 05.06.08 | TITLE | BASKET LID ASSEMBLY | SHEET 2 OF 2 | SCALE |
| | | | | | 1:10 |

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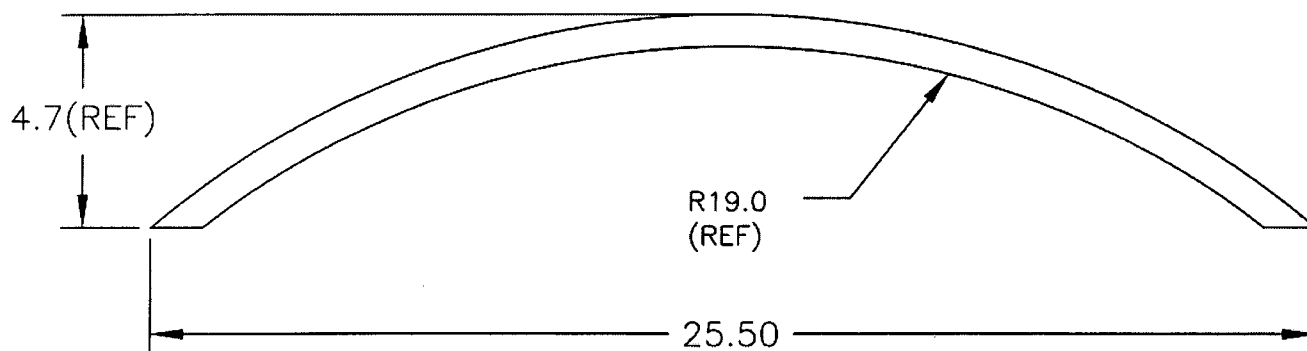
05.08.19

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| DESIGN BW | DRAWN BY PH | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED ## | APPROVED ## | DRAWING NO. D2236 | REV. C SHEET 1 OF 1 |
| DATE 05.06.07 | TITLE LID RIB | | SCALE 1:4 |
| A | 94.05.30 | NEW ISSUE | |
| B | 94.12.16 | LID | |
| C | 05.06.07 | UPDATE NOTES, CHANGE RADIUS TO 19.0 | |

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05.08.19 ##

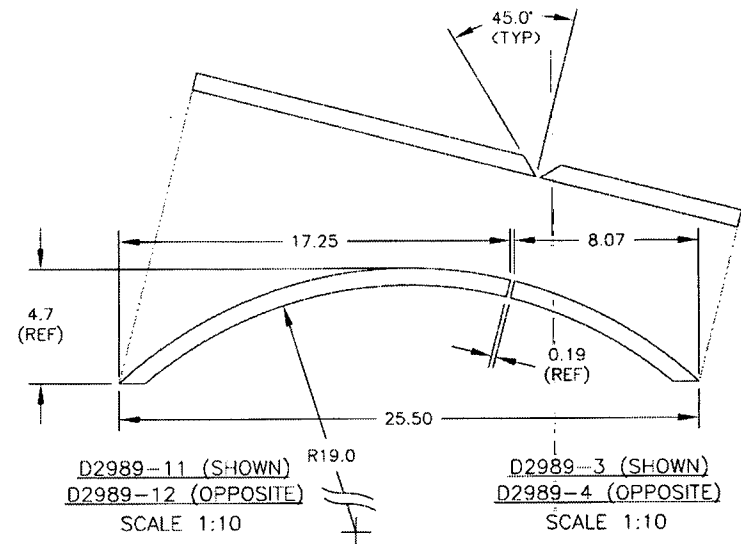
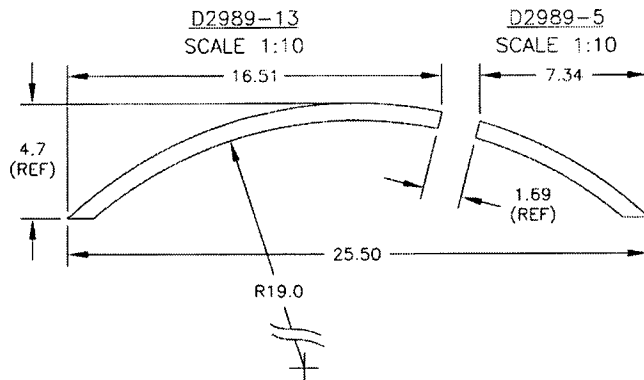
**D2236 LID RIB**

- 1) MAKE FROM D3166-3 BASKET HOOP
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES AER PER DART QSI 018 UNLESS OTHERWISE NOTED

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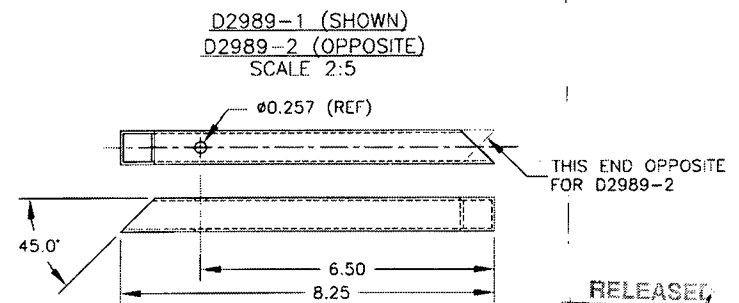
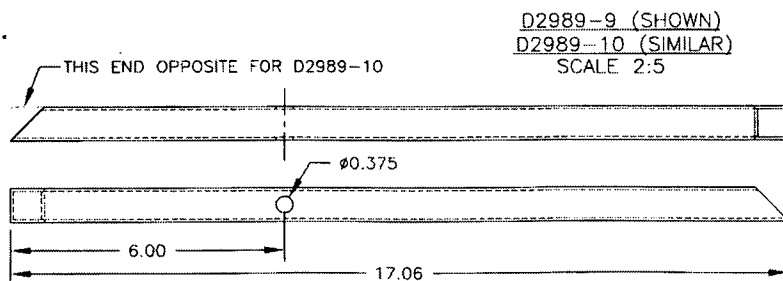
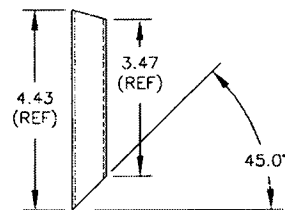
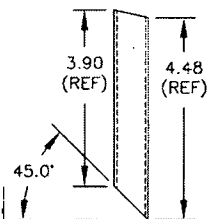
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D2989-15
SCALE 2:5
(DIMENSIONS LISTED AS REFERENCE ONLY, CUT TO FIT ASSEMBLY)

D2989-7
SCALE 2:5
(DIMENSIONS LISTED AS REFERENCE ONLY, CUT TO FIT ASSEMBLY)



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05-08-19

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| | | | | CHECKED | | APPROVED | | DRAWING NO. | | REV. B | |
| | | | | DATE | | TITLE | | D2989 | | SHEET 3 OF 3 | |
| | | | | 05.06.07 | | BASKET LID ASSEMBLY | | | | SCALE | |
| | | | | | | | | | | 1:10 | |

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